

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014183**Date Inspected:** 19-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Liming Yang.
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 1: CB15:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Bay 8: CB17:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Outside Yard:

CB11, CB12, CB13 & CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

CB14:

During random inprocess inspection of this Cross Beam, this QA Inspector observed ZPMC personnel performing base metal repair welding on Floor Beam: FB202G-044. ZPMC QC is identified as Guo Yuan Ting. Welder was identified as 049861. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-1G(1F)-FCM-Repair (welding repair report (WRR) no: B-WR12998 Rev-0 Dt: 05/10/10. This repair welding is needed to be done on FB202G-044 & FB202G-041; on locations from where the temporary attachments were removed.

Refer attached photos for reference.

Trial Assembly:

CB7:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present. This QA Inspector did random inprocess visual inspection of the Deck Panel hold back welds. Areas identified as not to be complying with the contract documents were marked in question for the Contractors QC to inspect and evaluate.

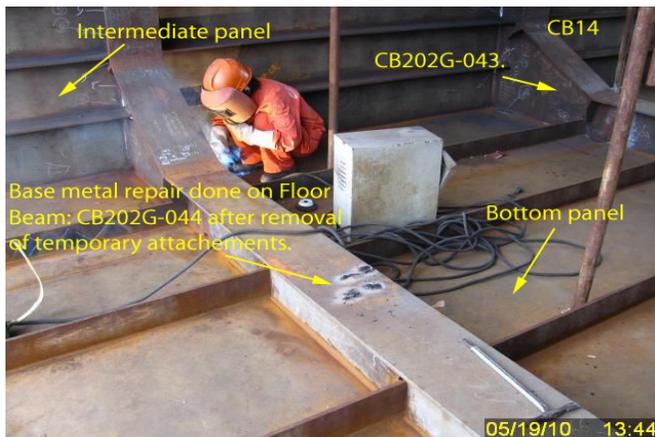
CB9:

During random inprocess inspection of this Cross Beam, this QA Inspector observed ZPMC personnel doing fit-up of side panel of CB9 and FL3 side panels of OBG segments 8AE & 8AW.

CB8 & CB10:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
